

Work Order ID 139891

December 11, 2015 3:14:08 PM

139891

Ship Jan. 15th
Page 1

Item ID: D2432-3 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: 206 (24") Bearpaw
Start Date: 12/11/2015 Start Qty: 8.00 *8* Cust Item ID:
Required Date: 1/15/2016 Req'd Qty: 8.00 *8* Customer:
Reference:

Approvals: Process Plan: SH Date: 12/11/15 Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2432	H

120 0.00
120 FLOW WATER JET
Waterjet Memo 0.03
FLOW CNC Waterjet Cut Blank as per D2432 File
9 0 16-1-5

130 0.02
130 HAAS CNC VERTICAL MACHINING #1
HAAS 1 Memo 0.15
HAAS CNC vertical machine #1
1-Inspect material for defects or damage prior to machining
2-Machine as per Folio and Dwg D2432 Identify as D2432F
3-Deburr
9 0 15/01/16

140 0.00
140 QC2- Inspect parts off machine FAI/FAIB
QC Memo 0.00
Quality Control
9 0 16/01/06

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JAN 12 2016

Picklist Print

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Work Order ID: 139891

139891

Parent Item: D2432-3

D2432-3

Parent Item Name: 206 (24") Bearpaw

Start Date: 12/11/2015

Required Date: 1/15/2016

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A AS PER REV G 12-07-24 JLM VERIFIED BY:DD IPP
REV:B 12.10.17 AS PER DWG REV.H DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			120	sf	343.1000	3.7	29.6			

MIJHMWB10

UHMW 1" Black - 48"x120" Tivar Mfg.#52480104

12 16-1-5

Location

MAT018

Loc Qty

343.1

Loc Code

m133248

38.9

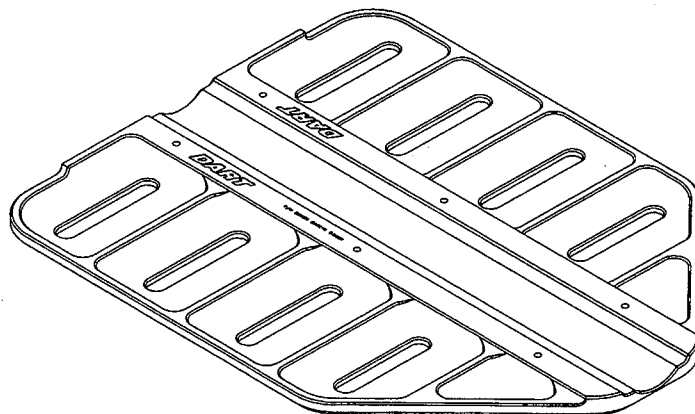
m133642

304.2

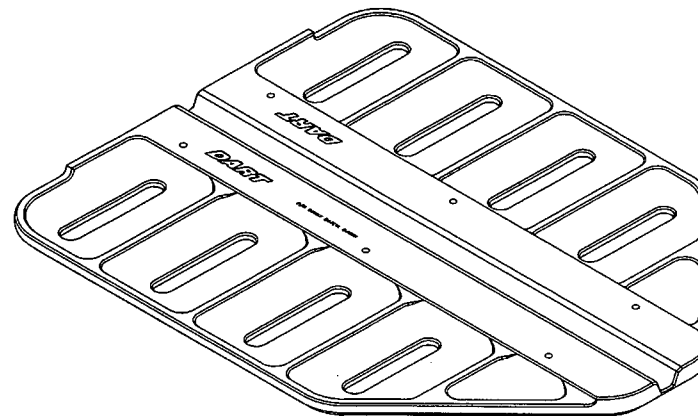
8'
35.2

43.2

~~20~~ 22.2
+ 13.



D2432F BEARPAW



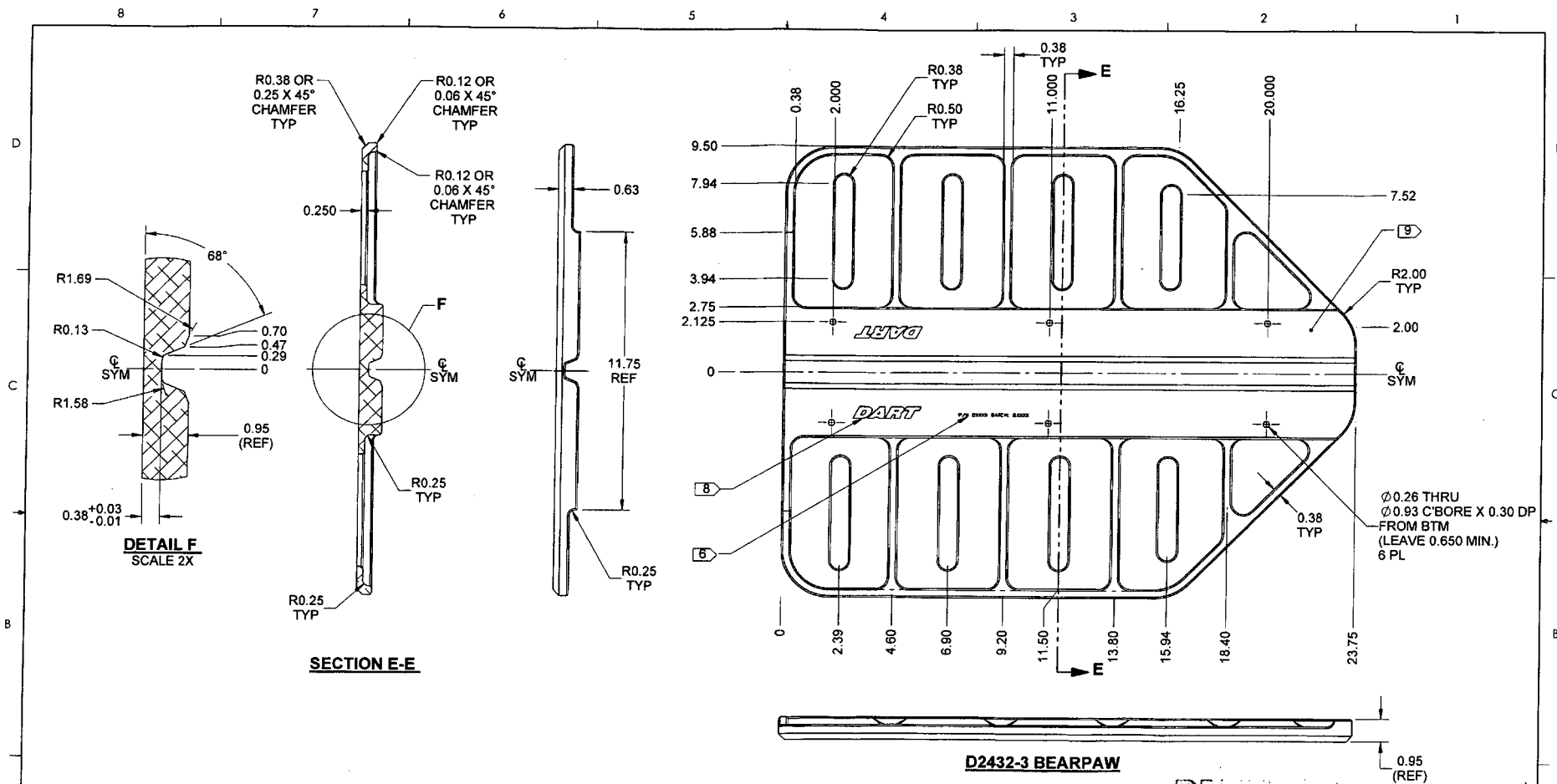
D2432-3 BEARPAW

RELEASED
R 2012-10-16

H	RIB HEIGHTS CHANGED TO CONDITION OF REV. F. SEE REV. F FOR DETAILS.	AP	12.09.24
G	UPDATE DRAWING FORMAT, REMOVED D2432B, ADD D2432-3, ADDED DIMENSION 7.52 (D1-2)	AP	12.05.02
F	CHANGE C'BORE, ADD B AND F P/N	-	98.05.12
E	CHANGE C'BORE DEPTH, BORE RADIUS	-	97.02.27
D	MOVE SLOT	-	96.06.04
C	CHANGE BORE AND C'BORE DEPTH	-	96.03.26
B	RE-DESIGN	-	96.01.24
A	NEW ISSUE	-	95.10.31
REV.	DESCRIPTION	BY	DATE
DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	AS	DRAWING NO.	REV. H
MFG. APPR.	9/1	D2432	SHEET 1 OF 3
APPROVED	1/0	TITLE	SCALE
DE APPR.	1/0	BEARPAW	NTS
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20151211

SH139 891



- NOTES:**
- 1) MATERIAL: UHMW BLACK TIVAR 1000 VIRGIN MATERIAL, 1.000 THICK MACHINED TO 0.950 (REF DART SPEC. MUHMWB10)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: ENGRAVE PART NUMBER "D2432-3" AND BATCH NUMBER "BXXXXX" IN ACCORDANCE WITH QSI 044 METHOD 6.3
 - 7) WEIGHT: 6.25 lbs
 - 8) ENGRAVE DART LOGO TO MAX DEPTH OF 0.012
 - 9) APPLY 0.06 x 45° CHAMFER TO ALL EDGES ON SIDE SHOWN UNLESS OTHERWISE INDICATED
 - 10) PROFILE PER DRAWING FILE "D2432-3-REVH.STP"

DESIGN	LE	DART AEROSPACE LTD	
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ALS	DRAWING NO.	REV. H
MFG. APPR.	dt	D2432	SHEET 3 OF 3
APPROVED	dt	TITLE	SCALE
DE APPR.	dt	BEARPAW	NTS
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DART AEROSPACE LTD		Work Order:	139891
Description: Bearpaw		Part Number:	D2432
Inspection Dwg: D2432 -3 Rev: H		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 0.063 x 45°	+0.030/-0.010	0,053	✓		MIP-04	vern
B 0.200	+/-0.030					
C 0.25 x 45°	+/-0.030	0,250 x 45°	✓		...	...
D R0.250	+/-0.030	0,250	✓			Radius gauge
E 0.250	+/-0.010	0,258	✓		MIP-04	vern
F 0.625	+/-0.030	0,640	✓		...	...
G 0.375	+0.030/-0.010	0,385	✓		↓	↓
H 0.950	+/-0.030	0,965	✓		↓	↓
I 19.000	+/-0.030	19,000	✓		MIP-07	Tape
J Ø0.260	+0.005/-0.000	0,260	✓		MIP-04	vern
K Ø0.93	+/-0.030	0,930	✓		...	...
L 0.30	+0.030/-0.000	0,320	✓		↓	↓
M 23.750	+/-0.030	23,750	✓		↓	↓
N 2.000	+/-0.030	1,990	✓		↓	↓
O 0.38	+/-0.030	0,375	✓		↓	↓
P Ø, 70	± 0,030	0,715	✓		↓	↓
Q					↓	↓
R						
S						
T						
U						
V						

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>	Preliminary Approval:
Date: 16/01/06	Date: 16/01/12	Date:

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue P/O D206-559-015	KJ/RF	
B	12.07.31	Dwg Rev updated	KJ	
C	12.10.26	Dwg Rev updated	KJ	
D	13.07.18	Dimension 7.375 removed	KJ	
E	15.02.09	Dimensions revised	KJ	<i>[Signature]</i>